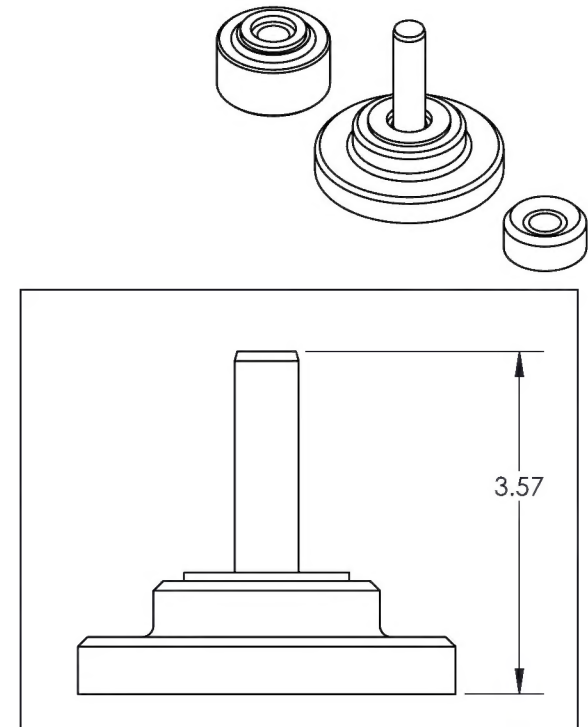
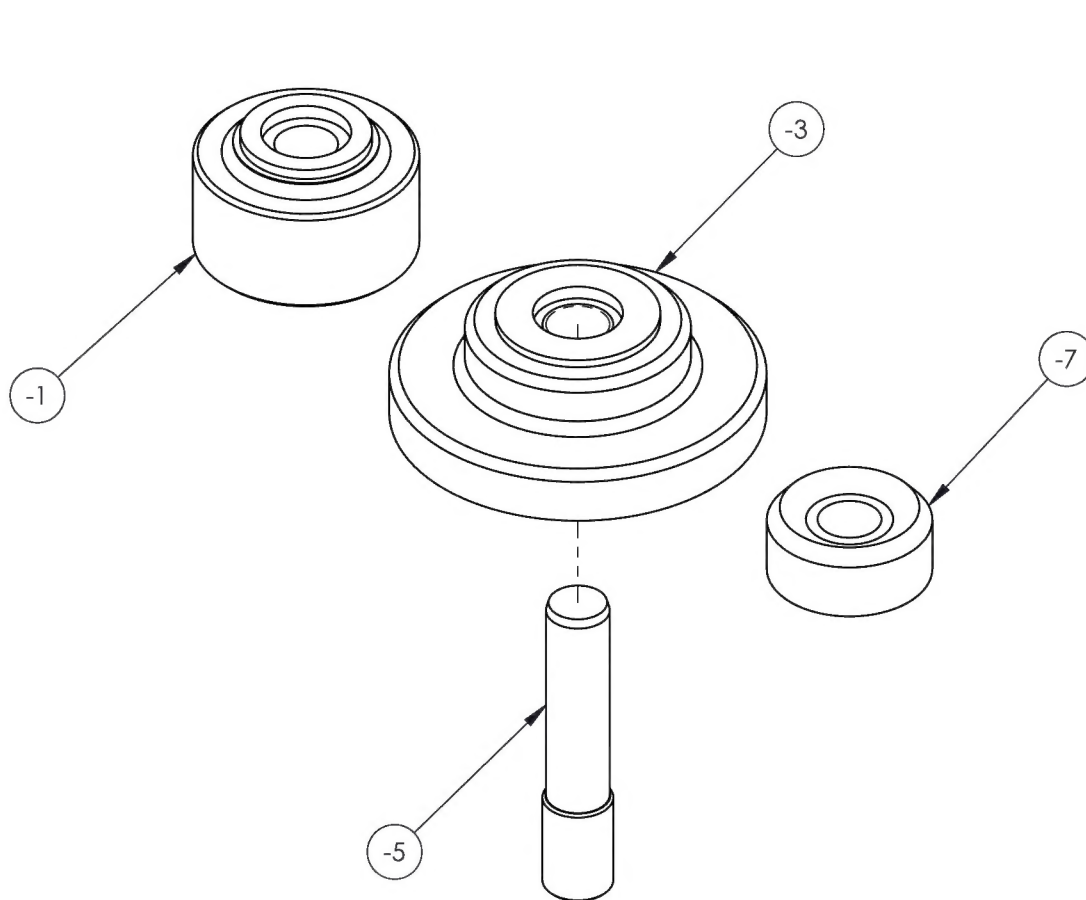


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	10/25/2016	SM	JAG



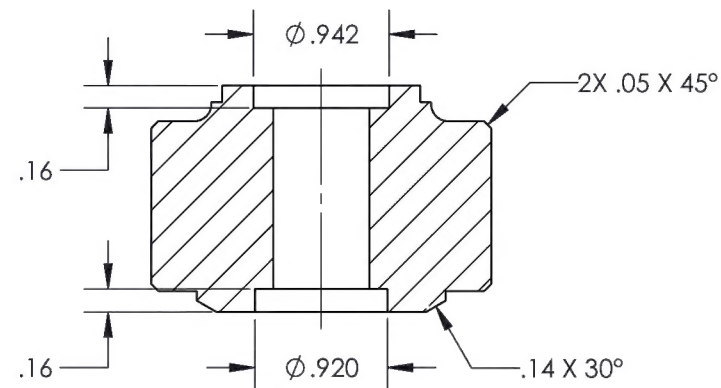
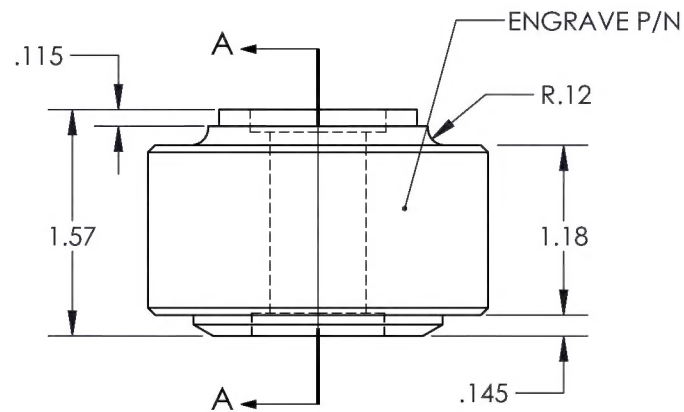
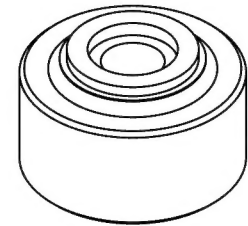
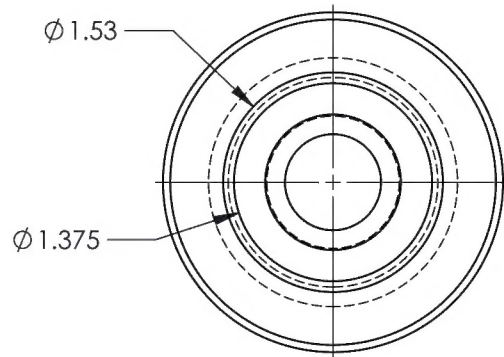
- NOTES:
 1. REF. AIRBUS T/N: 117-44115W1.
 2. PRESS -5 INTO -3.

DART AEROSPACE	
TITLE PRESSING-IN TOOL	
DWG NO. RBE117-44115W1	REV 1
MAT'L _____ HEAT TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H145, EC145	
SCALE 1:2	DATE 7/27/2016
SHEET 1 OF 5	

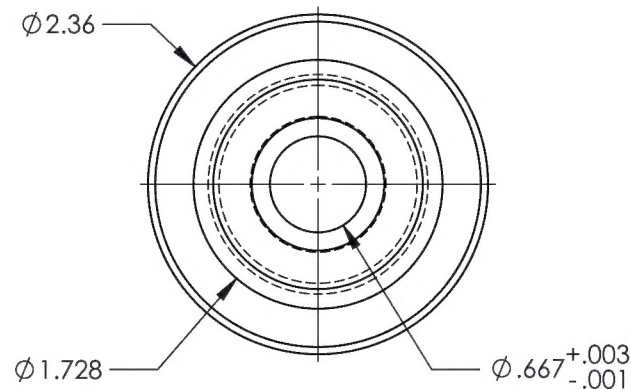
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SPACER 1	4140/4142	INTERMEDIATE RING	2
			-3	1	PLATE	4140/4142		3
			-5	1	ROD	4140/4142		4
			-7	1	DRIFT	4140/4142		5

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SECTION A-A



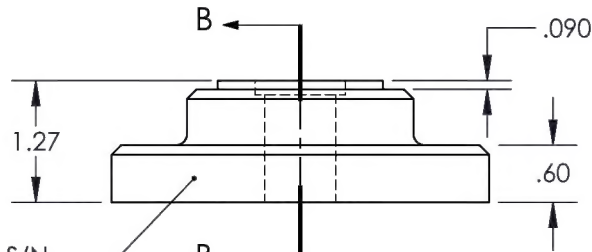
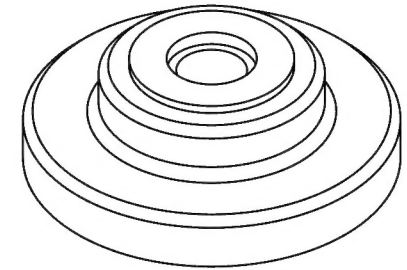
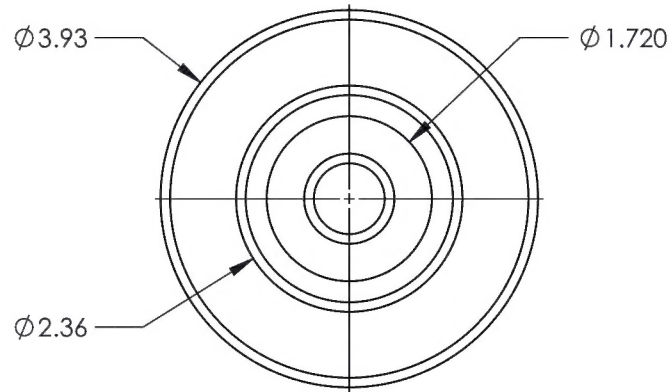
(-1)

SPACER 1

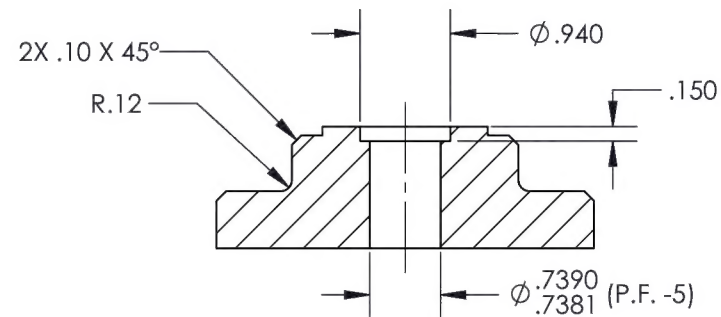
DART AEROSPACE	
TITLE PRESSING-IN TOOL	
DWG NO. RBE117-44115W1-1	REV 1
MAT'L 4140/4142 HEAT RC 46-52 TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H145, EC145
SCALE 3:4	DATE 7/27/2016
SHEET 2 OF 5	

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				APPROVED



ENGRAVE T/N, S/N,
"MADE IN USA"



SECTION B-B

(3)

PLATE

DART AEROSPACE	
TITLE PRESSING-IN TOOL	
DWG NO. RBE117-44115W1-3	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 46-52	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: MACKOVJAK	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/27/2016	USED ON MODEL
SHEET 3 OF 5	H145, EC145

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

$\phi .7400$
 $\phi .7396$
 (P.F. -3)

$\phi .665$
 $\phi .663$

$.10 \times 15^\circ$
 3.57
 $2X .03 \times 45^\circ$
 1.115
 ENDS OK

(-5)

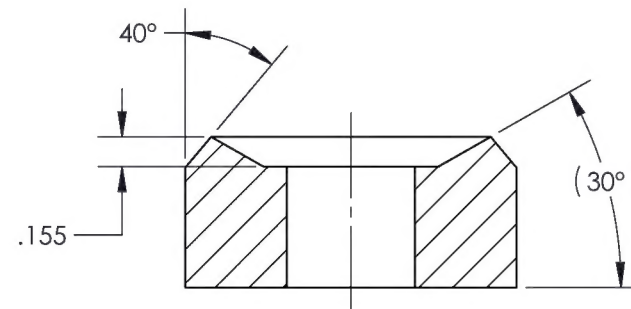
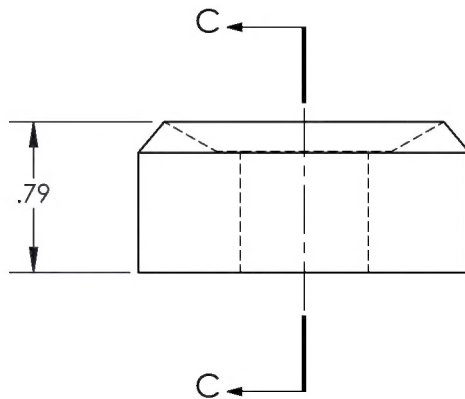
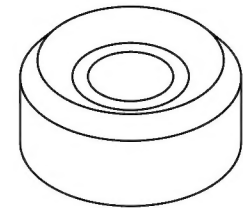
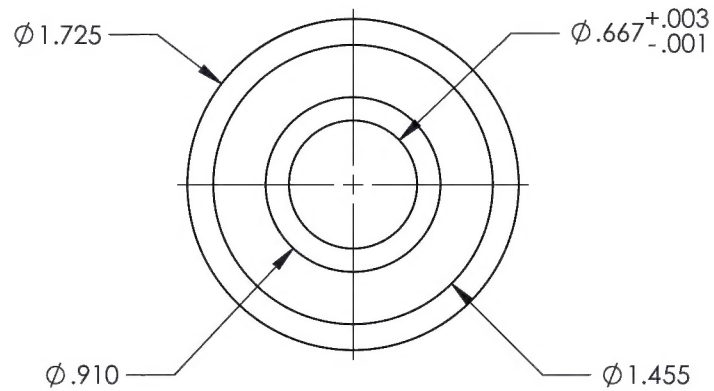
ROD



TITLE		PRESSING-IN TOOL	
DWG NO.		RBE117-44115W1-5	
REV		1	
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT RC 46-52		DIMENSIONS ARE IN INCHES	
TREAT		.XXX \pm .005 FRACTIONS \pm 1/8	
FINISH ZINC PLATE		.XX \pm .01 ANGLES \pm .5°	
SPEC ASTM B633 TYPE I SC 2		.X \pm .1 SURFACES = 125°	
DRAWN BY: MACKOVJAK		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
SCALE 2:3		ASME Y14.5M-2009	
DATE 7/27/2016		USED ON MODEL	
SHEET 4 OF 5		H145, EC145	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION C-C

(-7)

DRIFT

DART AEROSPACE	
TITLE PRESSING-IN TOOL	
DWG NO. RBE117-44115W1-7	REV 1
MAT'L 4140/4142 HEAT TREAT RC 46-52 FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H145, EC145
SCALE 1:1	DATE 7/27/2016
SHEET 5 OF 5	